Work Order ID 5797	78	97	579	-57	ID	der	Or	ork	W
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April 21, 2010 10:05:21 AM

Required Date: 28/04/2010



Page 1

Item ID:

D3953-3

Accept

Setup Start

Stop



Revision ID:

Item Name: Gas Spring Stud, Lid

Start Date:

21/04/2010

Start Oty: 6.00

Req'd Qty: 6.00



Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

C

OC:

Date: 10-4-2/ Tooling:

Date:

SPC (Y/N):

Date:

Date:

Start Run

Stop

Sequence ID/ Work Center ID

Draw Nbr

Operation Description

Revision Nbr

Set Up/ Run Hours Draw Number

Plan Draw Rev.

Accept **Qty**

Code

Reject Otv

Reject Insp. Number Stamp

D3953 100

Doosan Lathe

Memo

Turn as per folio FA852 & DWG

FOLIO REV: DWG REV

0.00

0.00

10/04/25

DEBURR

Memo

110

QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

0.00

0.00

10/04/25

	•								
W/O:			W	ORK ORDER CHANG	ES				
DATE	STEP	PRO	OCEDURE CH	ANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
									
Part No	! •	PAR #:	Fault Cate	adory.	NCP: Vos	No DO	Λ.	Data	<u> </u>
		solution:							
				ER NON-CONFORMA				Date	
NCR:			WORK ORL		INCE (INCE	1) 		·	•
DATE	STEP	Description of NC	Corrective Action Section B Initial Action Description			Sign & Verification		Approval	Approval
		Section A	Chief Eng	Action Description Chief Eng	Date	Secti	on C	Chief Eng	QC Inspector

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Work Order ID 57978

April 21, 2010 10:05:21 AM

Required Date: 28/04/2010



Page 2

Item ID:

D3953-3

Revision ID:

Item Name: Gas Spring Stud, Lid

Start Date:

21/04/2010

Start Qty: 6.00

Req'd Qty: 6.00



Date: _____

Accept



Setup Start

Stop



Reference:

Approvals:

Process Plan:

QC: ____

Date:

Tooling:

0.00

SPC (Y/N):

Date:

Date:

Start Run

Stop



Sequence ID/ Work Center ID

120

Quality Control

Operation Description

QC8- Inspect parts - second check

Set Up/ **Run Hours**

Draw Number

Cust Item ID:

Customer:

Draw Rev.

Plan Accept Code **Qty**

Reject Qty

Reject Number Stamp

Insp.

Memo

0.00 and 10/04/28

130

Packaging

Packaging

Memo

Identify as per dwg & Stock Location: ST 1010.00 m-1 w/04/26

140

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

BS 10-4-26

	•									
W/O:			W	ORK ORDER CHANGI	ES					
DATE	STEP	PROC	CEDURE CH	ANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
:										
Part No	•	PAR #:	Fault Cat	legory:	NCR:	Yes N	o DQ /	\	Date:	
			Disposition: QA: N/C Closed:							
NCR:		W	ORK ORI	DER NON-CONFORMA	NCE ((NCR)				
DATE	STEP	Description of NC Section A	Corrective Action Section Initial Action Description Chief Eng Chief Eng			Sign & Date		ation on C	Approval Chief Eng	Approval QC Inspector

						<u>.</u>				

Picklist Print

April 21, 2010 10:05:26 AM

Work Order ID: 57978

Parent Item:

D3953-3

Parent Item Name:

Gas Spring Stud, Lid

Comments:

IPP RevA: New issue DD verified by:EC

DD 10.03.02 verified by:EC



IPP Rev:B as per dwg revC

Start Date: 21/04/2010

Qty

Issued

Required Date: 28/04/2010

Start Qty: 6.00

Required Oty: 6.00

Component Item ID/
Item Name

M304RO.750

Replacement Mfg/ Item ID Purch

Mfg/
Purch
Purchased

Bin Primary Item Location

Last Location Route Seq ID Unit of Qty on Measure Hand 59,0000

Remaining Qty To Pick 0.7895

Date Issued

Status

Page 1

ATTERNATURE AND CONTRACTOR TO THE STATE OF T

304 SS Roundbar .750

Warehouse	Loc Oty		Loc Code
Location			
Main Warehouse			
MAT028	59		
113216	24.75	,	
113457	34.25		

1.0 3/10/04/25

W/O:			WO	RK ORDER CHANG	SES			1945 - H		·
DATE	STEP	PRO	OCEDURE CHAN	IGE		Зу	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No	:	PAR #:	Fault Categ	ory:	_ NCR:	Yes I	lo DQ	A :	Date: _	
	Re	solution:	Disposition	:	QA: N	/C Clo	sed:		Date:	
NCR:			WORK ORDE	R NON-CONFORM	ANCE (NCR))			
DATE	STEP	Description of NC	Description of NC Corrective Action			on B Verifica			Approval	Approval
		Section A	Initial Chief Eng	Action Description Chief Eng	cription Sign & Date		Section C		Chief Eng	QC Inspector
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DART AEROSPACE LTD	Work Order:	57978
Description: Gas Spring Stud, Lid	 Part Number:	D3953-3
Inspection Dwg: D3953 Rev: C		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article	Prototype
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Drawing		Actual	7.		Method of	
Dimension	Tolerance	Dimension	Accept	Reject	Inspection	Comments
Ø0.75	+/-0.030	D.750				·
0.56	+/-0.010	.559				
0.281	¯+/÷0:010	.280			-	
1/4-28 UNF-2A	N/A	14-28-104			,	
Major Ø	Max = 0.2490 Min = 0.2425	. 2453				
M.O.W.	Max = 0.26687 Min = 0.26357	264				
Ø0.098	+0.004/-0.001	Ø.101				
Ø0.250	+/-0.010	0,243				
0.170	+/-0.010	173				
0.330	+/-0.010	330	-/			
0.13	+/-0.030	-130	/.			
R0.06	+/-0.030	R.06				
1.31	+/-0.030	1313				

Measured by:	die	Audited by:	and	Prototype Approval:	N/A
Date:	10104125	Date:	10/04/26	Date:	N/A

Rev	Date	Change	Revised b	У	Approved
Α	09.10.22	New Issue	KJ		
В	09.12.14	Dwg Rev updated	KJ ¢	A	M
				//	

	•										
W/O:			W	ORK ORD	ER CHAN	GES					
DATE	STEP	PR	OCEDURE CH	ANGE			Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No	:	PAR #:	Fault Cat	tegory:		NCI	R: Yes	No DQ	4 :	Date:	
							QA: N/C Closed: Date:				
NCR:			WORK ORI								
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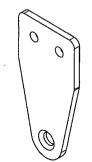
NOTE: Date & initial all entries

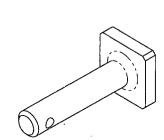
SHOP COPY RETURN TO ENGINEERING UNCONTROLLED COPY

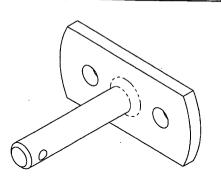
SUBJECT TO AMENDMENT WITHOUT NOTICE

WORK ORDER













D3953-3 GAS SPRING STUD, LID

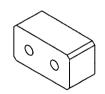
D3953-5 GAS SPRING STUD, BASE

D3953-7 GAS SPRING SPACER

D3953-9 GAS SPRING WASHER C

D











D3953-11 GAS SPRING SPACER

D3953-13 GAS SPRING SPACER (FULL LID)

D3953-15 GAS SPRING BRACKET (SPLIT LID)

D3953-17 GAS SPRING SPACER (SPLIT LID)

D3953-19 GAS SPRING BRACKET
(SQUARE BASKET)

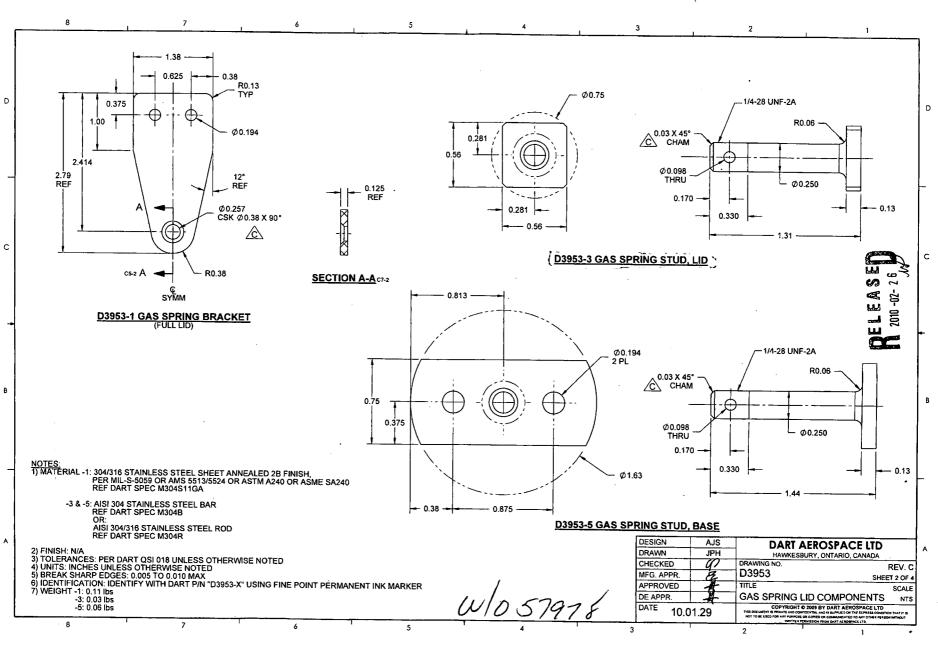




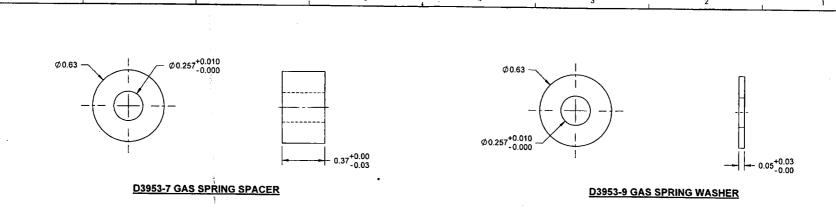


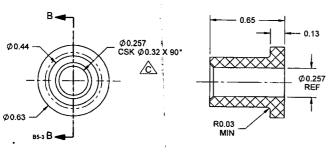
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c	PARTS CHAM ((C7-2, C REASO	-19 & -21 ADDI C6-2, B6-3, C6- (7-4); SECTION N: ADDL PART	ED (SHT 18 4); CSK CALLOUT WAS 4); © SYMM WAS © SYM ABOUT 10 C-C REPOSITIONED TO 82-4 S REQD; DRAFTING ERRORS	JPH	10.01.29
В	SHEET DIMENS REASO ASSY.	3 ZONE C1, DI SIONS MIN/MAI N: DIFFICULTY	M 0.05 MIN WAS 0.13, MULTIPLE X REMOVED TOLERANCE ADDED. / INSTALLING COTTER PIN AT NEXT	AJS	09.11.11
Α	NEWIS	SUE		AJS	09.07,27
REV.			DESCRIPTION	BY	DATE
DESIG	N	AJS	DART AEROSPA	CFL	ľD
DRAW	N .	JPH	HAWKESBURY, ONTAR		
CHECK	ED	a	DRAWING NO.		REV. C
MFG. A	PPR.	B	7 D3953		SHEET 1 OF 4
APPRO	VED	-4-	TITLE		SCALE
DE APP	PR.	#	GAS SPRING LID COMP	ONEN	
DATE	10.0	EROSPACE ON THE EXPAIL	LTD CONDITION THAT IT IS EN PERSON WITHOUT		

W/O:				V	ORK ORDER CHANG	ES					· · · · · · · · · · · · · · · · · · ·	
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1.38 -0.38 0.625 0.63 Ø0.194 2 PL 0.75 0.375 0.06 X 45° CHAM TYP

D3953-11 GAS SPRING SPACER

SECTION B-B B7-3

D3953-13 GAS SPRING SPACER

NOTES: 1) MATERIAL -7,-9 & -11: DELRIN II 150E OR ACETRON GP ACETAL, BLACK REF DART SPEC M-DELRIN-R

-13: AISI 304 STAINLESS STEEL BAR REF DART SPEC M304B

2) FINISH: N/A

8

2) FINISH: N/A
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION -13 ONLY: IDENTIFY WITH DART P/N "D3953-13" USING FINE POINT PERMANENT INK MARKER
7) WEIGHT -7/-9/-11: < 0.01 ibs EACH

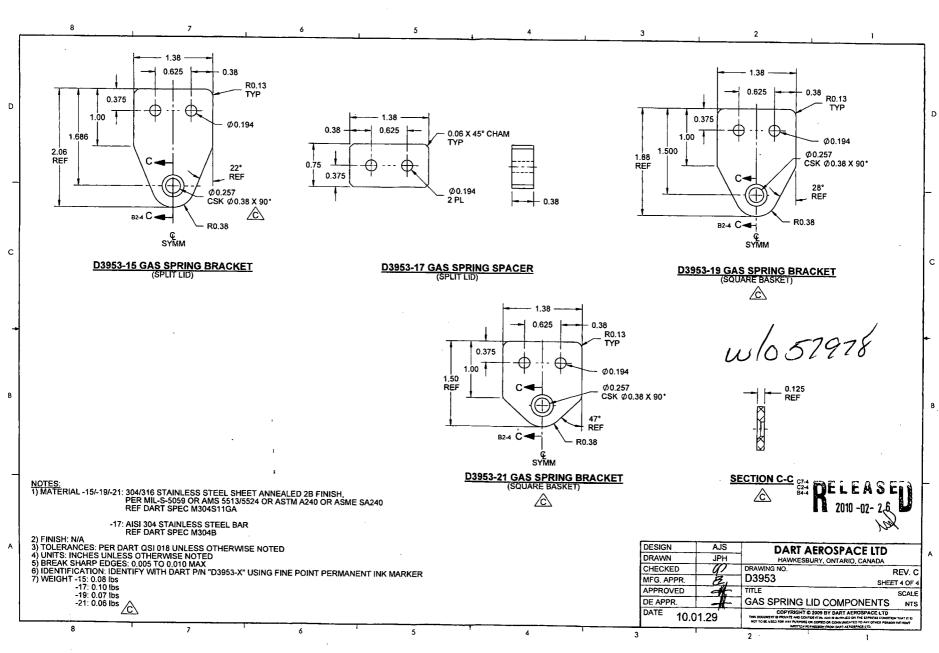
-13: 0.17 lbs

DESIGN AJS DART AEROSPACE LTD DRAWN JPH HAWKESBURY, ONTARIO, CANADA CHECKED DRAWING NO. REV. C D3953 MFG. APPR. SHEET 3 OF 4 **APPROVED** TITLE GAS SPRING LID COMPONENTS DE APPR. COPYRIGHT © 2009 BY DART AEROSPACE LTD
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HOT TO BE USED FOR ANY PURPOSE ON COMED ON CONNUMERATED TO ANY OTHER PRIN DATE 10.01.29

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